

Ship 18/09

Work Order ID 107036

107036

Page 1

September-16-13 11:18:14 AM

Item ID: D4636-043

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Receptacle Bracket Assembly

Start Date: 9/16/13

Start Qty: 16.00

16

Cust Item ID:

Required Date: 9/20/13

Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4636

C

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut D4636-3F as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

304-040

16 0 Ac 13.09.18

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

16 0 Ac 13.09.18

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

DAS
27
9-89

139 18

10 X

Work Order ID 107036

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September-16-13 11:18:14 AM

Item ID: D4636-043 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Receptacle Bracket Assembly
 Start Date: 9/16/13 Start Qty: 16.00 *16* Cust Item ID:
 Required Date: 9/20/13 Req'd Qty: 16.00 *16* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	NC BRAKE Memo 1- C'SINK HOLES AS PER DWG 2- BEND AS PER DWG 3- INSTALL RIGID RECEPTACLE AS PER DWG	0.00 0.00							Sb 1369/18
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							DAS 16 9-89 13/09/19 (Sign for inspection 627.)
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							106593 13/13/15 (16)

Work Order ID 107036***107036***

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September-16-13 11:18:14 AM

Item ID: D4636-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Receptacle Bracket Assembly
Start Date: 9/16/13 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 9/20/13 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

13/9/20 *[Signature]*
MF
13-9-19

Picklist Print

September-16-13 11:18:13 AM

Page 1

Work Order ID: 107036

Parent Item: D4636-043

Parent Item Name: Receptacle Bracket Assembly

Start Date: 9/16/13

Required Date: 9/20/13

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 12.04.30 NEW ISSUE DD VERF:EC IPP REV:B 13.06.20 DWG
PC2 DD VERF:JLM IPP REV:C 13.07.17 AS PER DWG REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
2350-18-C3Y Rigid Receptacle		Purchased	No				Each	129.0000		16		9/13/09/18	

Location	Loc Qty	Loc Code
ST396	129	
M126188	29	
M126740	100	

M304S20GA
304/316 .040 Sheet

Purchased No

sf 372.4900

Location	Loc Qty	Loc Code
MAT020	372.49001	
m125754	52.49001	
m126852	320	

MS20426AD3-
Rivet

Purchased No

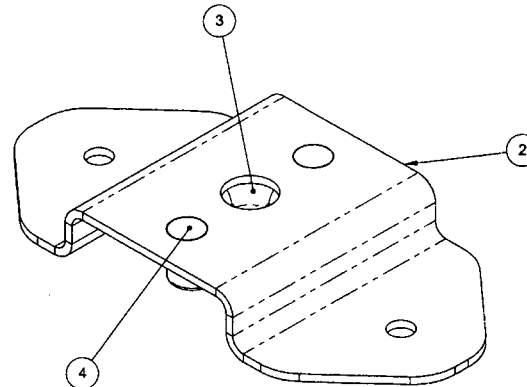
Each 18,153.000

Location	Loc Qty	Loc Code
Mezz	18153	
1173	8873	
13276	9280	

8 MS20426AD3-3
Rivet
30
12/09/18
M123352
32x

610
0.4042105
126852 → .41
32
9/13/09/18

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4636-043	RECEPTACLE BRACKET ASSY
2	1	D4636-3	RECEPTACLE BRACKET
3	1	2350-18-C3Y	RIGID RECEPTACLE
4	2	MS20426AD3-2	RIVET



D4636-043 RECEPTACLE BRACKET ASSY

107036 MJS
13-09-16

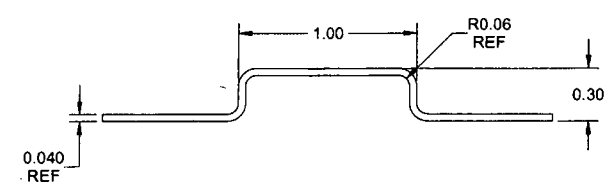
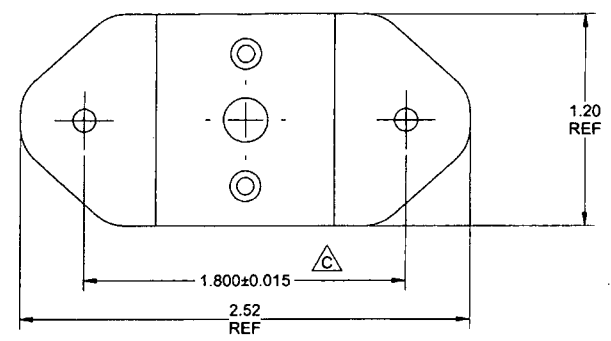
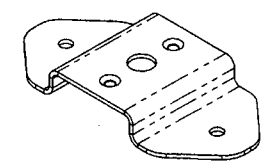
RELEASED
2013-07-15

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.044 lbs

C	REMOVE -041-11-1F; REVISE D4636-043/3 Ø 0.221 WAS Ø 0.500 (ZN C5-6); REVISE D4636-7 (ZN B4-5)	RF	13.06.18
B	2351-20-27-ZC3T WAS 2351-20-027-Z3CT (ZN D3-1)	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4636	SHEET 1 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
DATE	13.06.18	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

107037



D4636-3 RECEPTACLE BRACKET

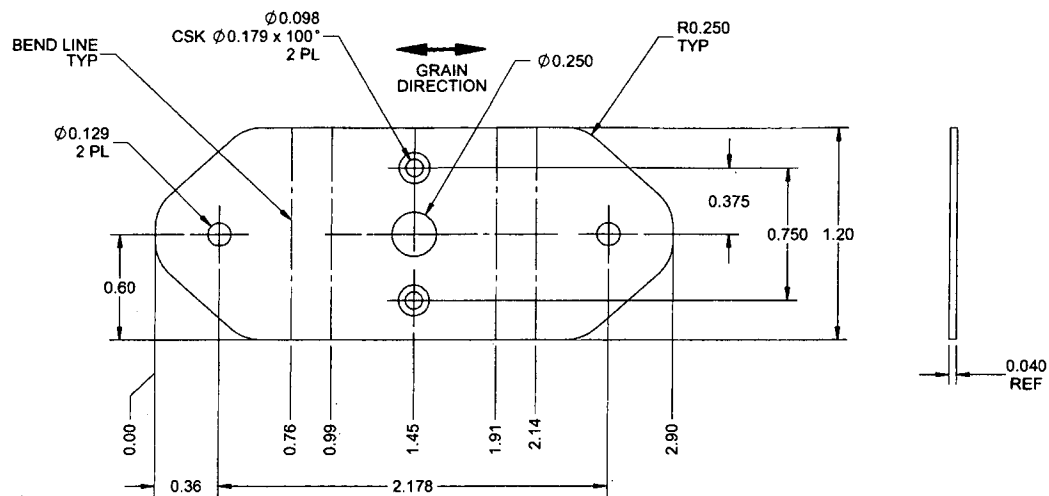
RELEASED
2013-07-15

- NOTES:**
- 1) MATERIAL: MAKE FROM D4636-3F FLAT PATTERN
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.03 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	RF	
CHECKED		DRAWING NO. D4636 REV. C
MFG. APPR.		SHEET 2 OF 7
APPROVED		TITLE BRACKET ASSEMBLY SCALE NTS
DE APPR.		
DATE	13.06.18	

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D4636-3F FLAT PATTERN RECEPTACLE BRACKET

NOTES:

- 1) MATERIAL: AISI 303 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR ASTM 240 OR ASME SA240
REF DART SPEC M303S20GA
OR AISI 304/316 SS SHEET, ANNEALED 2B FINISH
PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316)
OR ASTM 240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

RELEASED
2013-07-15
WJ

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D4636	SHEET 3 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET ASSEMBLY	NTS
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DART AEROSPACE LTD		Work Order: 107036
Description: <u>BRACKET</u> RECEPTACLE ASSEMBLY		Part Number: D4636-043
Inspection Dwg: 4636 Rev: REV C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.178	+/- .010	2.178	-		✓	okm-01
2.90	+/- .030	2.90	-		✓	okm-01
.36	+/- .030	.36	-		✓	
.76	+/- .030	.76	-		✓	
.99	+/- .030	.99	-		✓	
1.45	+/- .030	1.45	-		✓	
1.91	+/- .030	1.91	-		✓	
2.14	+/- .030	2.14	-		✓	
.60	+/- .030	.60	-		✓	
.375	+/- .010	.375	-		✓	
.750	+/- .010	.750	-		✓	
1.20	+/- .030	1.20	-		✓	
Ø .098	+ .004 - .001	.098	-		✓	
Ø .129	+ .005 - .001	.129	-		✓	
.040	+/- .010	.034	-		✓	
Ø .250	+ .005 - .001	.250	-		✓	

Measured by: <u>AK</u>	Audited by: <u>DAS 27</u> 9-89	Preliminary Approval:
Date: 13.09.18	Date: 1398	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15